

# Work Order ID 62241

Wednesday, September 22, 2010 3:37:24 PM



Page 1

Item ID: D3535-15

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 9/22/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 9/29/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan: H

Date: 10-9-22

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3535	Rev B

100 . 0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3535 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-  
Deburr if necessary

364 .640

10-9-30

(6)

110 . 0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

10-9-30

120 . 0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

810110101

(+6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 62241

Wednesday, September 22, 2010 3:37:24 PM

Page 2

Item ID: D3535-15

Accept

Setup Start

Revision ID:

Stop

Item Name: Wearshoe

Start Date: 9/22/2010 Start Qty: 6.00

Cust Item ID:

Required Date: 9/29/2010 Req'd Qty: 6.00




Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Brake NC	NC BRAKE	0.00				(6)			
Brake NC	Memo 1-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326 joggle as per Dwg D3535 using Jig DT8158 3-Identify as D3535-15	0.00							
140  QC	QC5- Inspect part completeness to step on W/O	0.00				(+6)			
Quality Control	Memo	0.00							
150  Powdercoat	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00				(6)			
Powder Coating	Memo START TIME: 9:00 FINISH TIME: 9:30	0.00							

SB 12/10/05

Sokolov

BL 10-10-7.

W/O:		WORK ORDER CHANGES					
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**Work Order ID 62241**

Wednesday, September 22, 2010 3:37:24 PM



Page 3

Item ID: D3535-15

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 9/22/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 9/29/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

8/10/10/07

0.00

Memo

x6

170



Packaging

Packaging

Identify as per dwg &amp; Stock Location

FP-18

0.00

BL 10-10-7

0.00

Memo

6

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

10/10/07  
ME  
10-10-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, September 22, 2010 3:37:28 PM

Page 1

Work Order ID: 62241



Parent Item: D3535-15



Parent Item Name: Wearshoe


Start Date: 9/22/2010

Required Date: 9/29/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 07-02-15 JLM  
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA  304/316 .040 Sheet		Purchased	No			100	sf	33.3987	1.0205	6.445263			



1810-9-30

Location

Loc Qty

Loc Code

MAT		10.6522
	114574	10.6522
MAT20		22.7465
	112885	2.7475
	113062	0.699
	115440	19.3

115672

115672

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	62241
<b>Description:</b> Wearshoe		<b>Part Number:</b>	D3535-15
<b>Inspection Dwg:</b> D3535 <b>Rev:</b> B		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.890	✓		V HB-02	
2.000	+/-0.010	2.000	✗		V	
5.650	+/-0.010	5.650	✓		T HB-01	
9.150	+/-0.010	9.150	✗		T	
14.400	+/-0.010	14.400	✗		T	
19.650	+/-0.010	19.650	✗		T	
24.900	+/-0.010	24.900	✗		T	
30.150	+/-0.010	30.150	✗		T	
33.650	+/-0.010	33.650	✗		T	
35.650	+/-0.010	35.650	✗		T	
39.150	+/-0.010	39.150	✓		T	
Ø0.188	+0.005/-0.001	.190	✗		V	
24.00	+/-0.030	24.00	✗		T	
16.00	+/-0.030	16.00	✗		T	
8.00	+/-0.030	8.00	✓		T	
5.00	+/-0.030	5.00	✗		V HB-02	
0.300	+/-0.010	.301	✗		V	
0.300	+/-0.010	.300	✓		V	
0.038	+/-0.010	.036	✗		V	

<b>Measured by:</b>	JB
<b>Date:</b>	10-9-30

<b>Audited by:</b>	S
<b>Date:</b>	10/10/01

<b>Prototype Approval:</b>	N/A
<b>Date:</b>	N/A

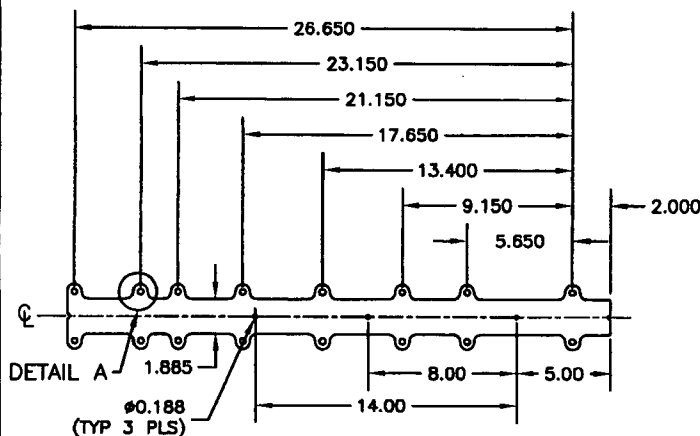
Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM	BE

**DART**

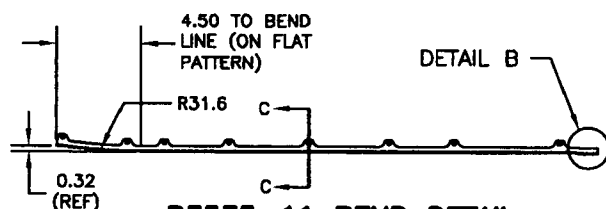
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07.04.24

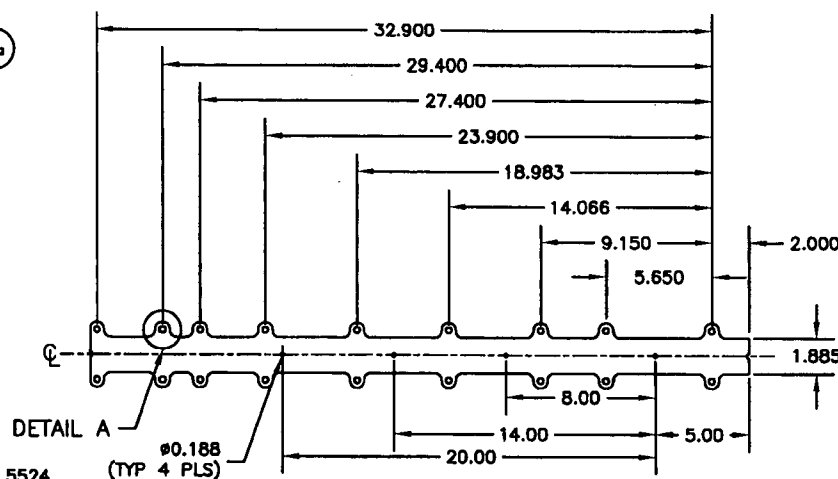
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UNCONTROLLED COPY  
SUBJECT TO APPROVAL  
WITHOUT A NEW  
WORK ORDER  
NO. 4224  
210-9-23



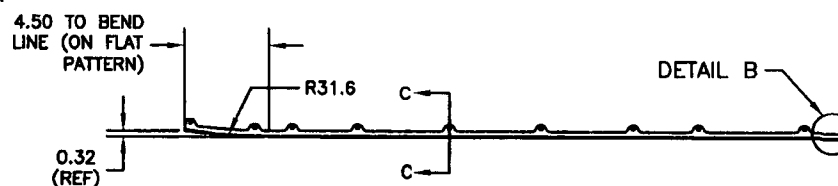
**D3535-11F FLAT PATTERN**



**D3535-11 BEND DETAIL**



**D3535-13F FLAT PATTERN**



**D3535-13 BEND DETAIL**

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. B
PH	PH	D3535	SHEET 1 OF 7
DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	
A	06.10.25	NEW ISSUE	
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

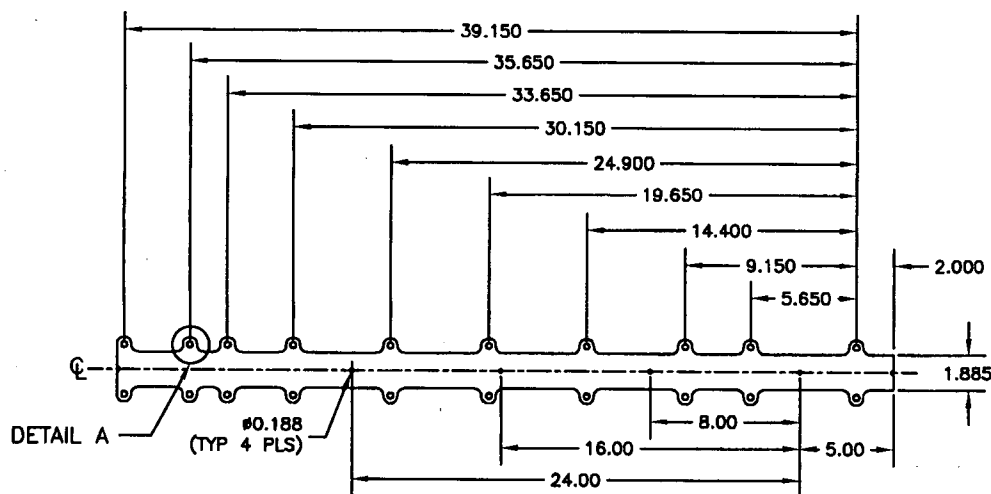
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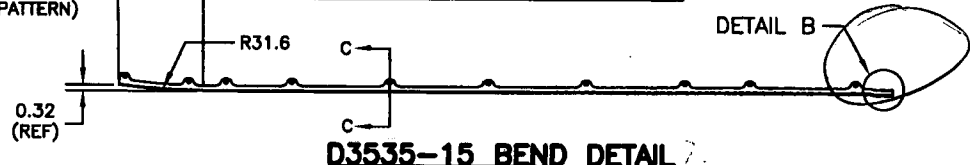
07.04.24

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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 2 OF 7
				SCALE 1:10

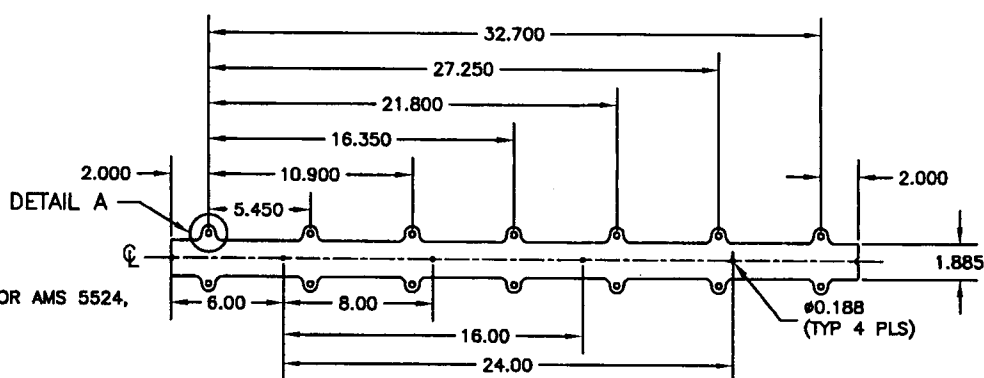


4.50 TO BEND  
LINE (ON FLAT  
PATTERN)

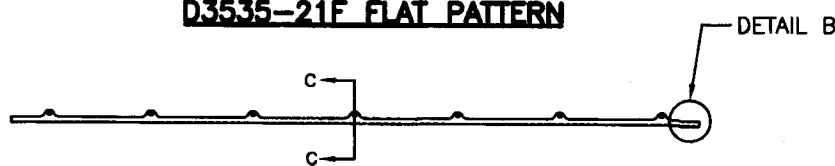
**D3535-15F FLAT PATTERN**



**D3535-15 BEND DETAIL**



**D3535-21F FLAT PATTERN**



**D3535-21 BEND DETAIL**

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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- 8) SEE PAGE 7 FOR DETAILS AND SECTION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

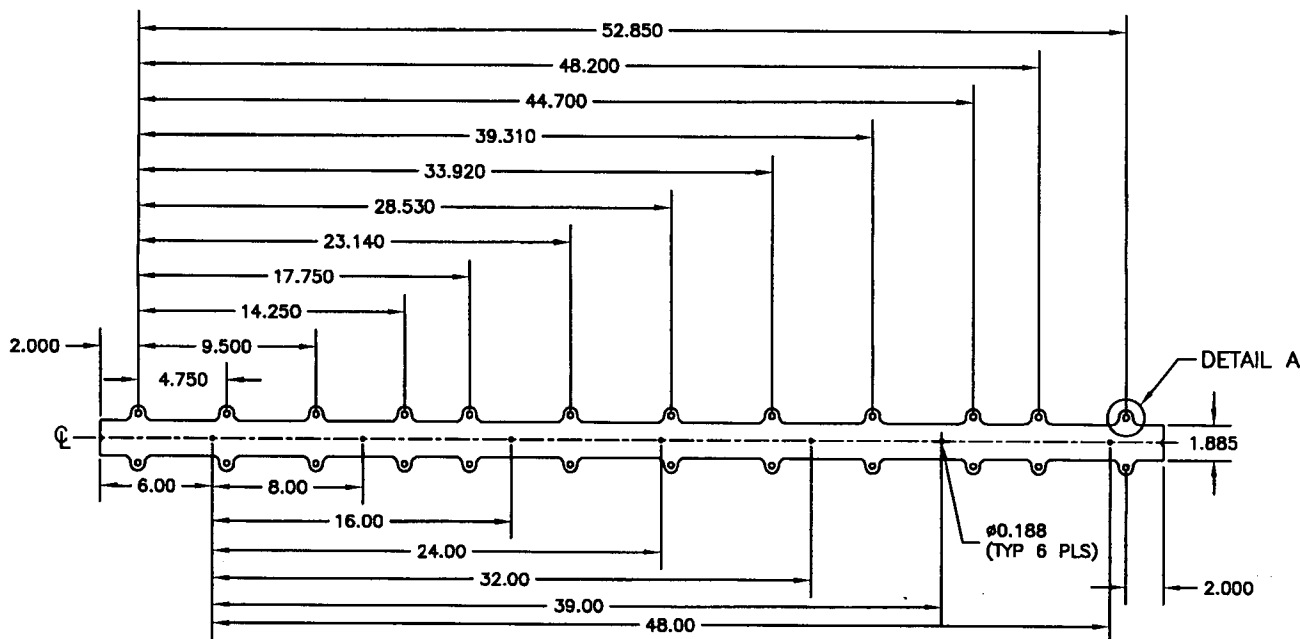
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

**DART**

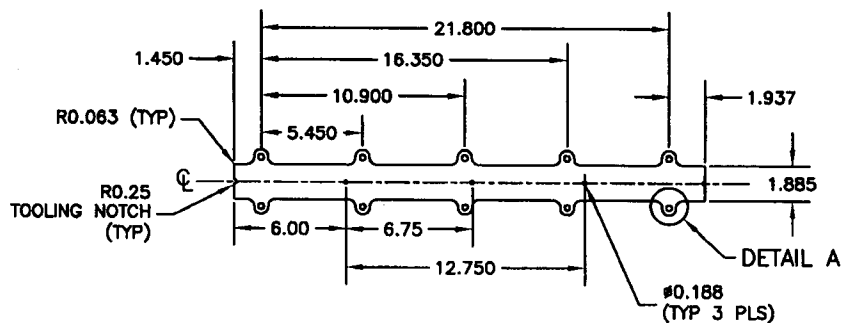
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**D3535-23F FLAT PATTERN**

**D3535-23 BEND DETAIL**



**D3535-25F FLAT PATTERN**

**D3535-25 BEND DETAIL**

**NOTES**

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DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
		D3535
DATE	TITLE	SCALE
07.04.17	WEARSHOE	1:10
		SHEET 3 OF 7
		REV. B

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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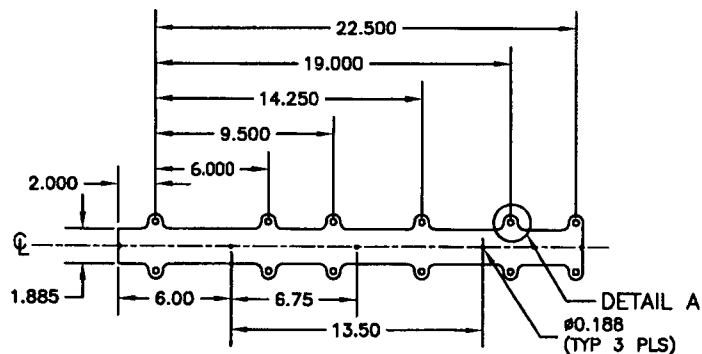
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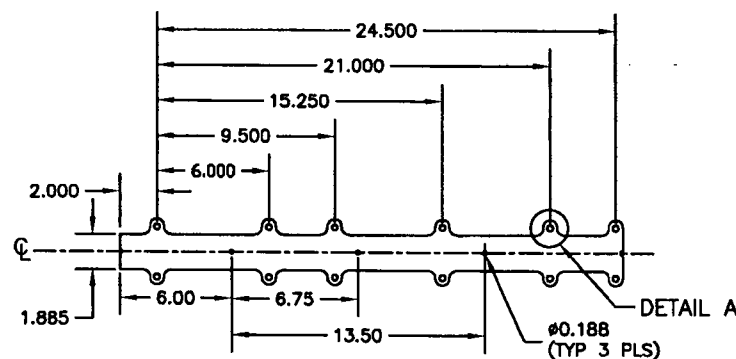
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**D3535-31F FLAT PATTERN**



**D3535-31 BEND DETAIL**



**D3535-33F FLAT PATTERN**



**D3535-33 BEND DETAIL**

**NOTES**

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		D3535	SHEET 4 OF 7
DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	



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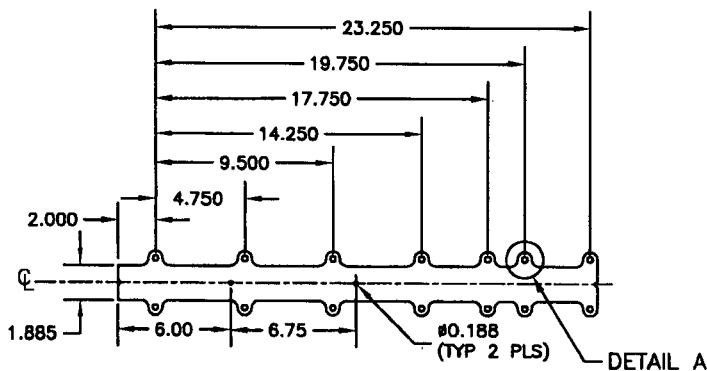
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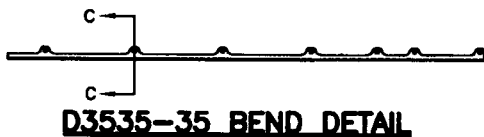
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07.04.17

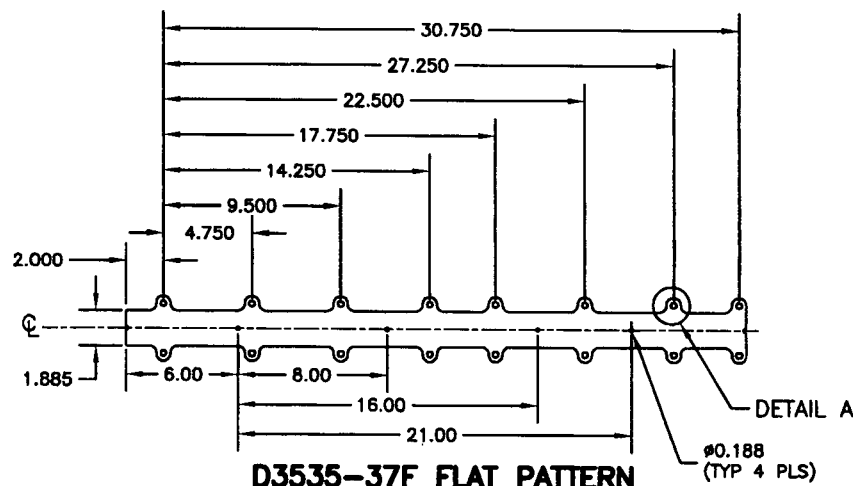
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DATE <b>07.04.17</b>	TITLE <b>WEARSHOE</b>	SCALE <b>1:10</b>	



**D3535-35F FLAT PATTERN**



**D3535-35 BEND DETAIL**



**D3535-37F FLAT PATTERN**



**D3535-37 BEND DETAIL**

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

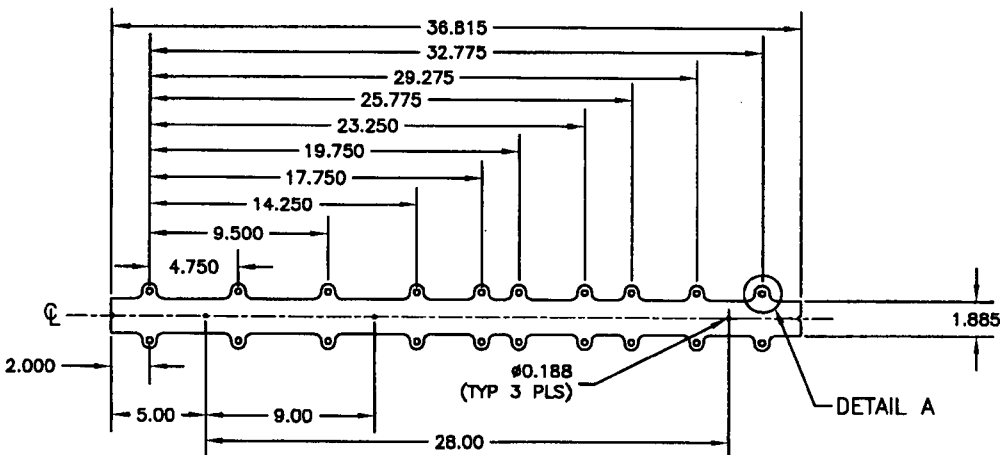
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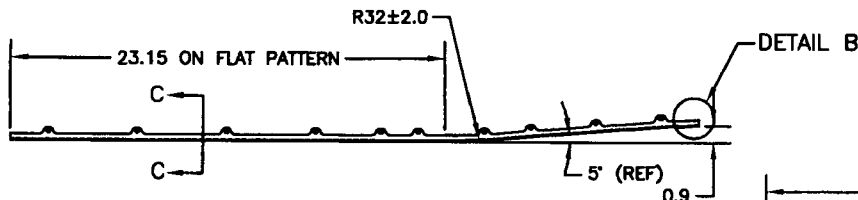
07.04.24

w/o 42247

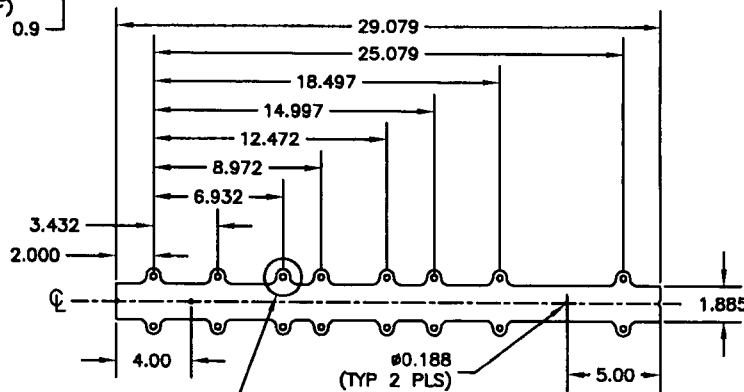
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CHECKED		APPROVED		PORT HADLOCK, WA
DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 6 OF 7
		SCALE	1:10	



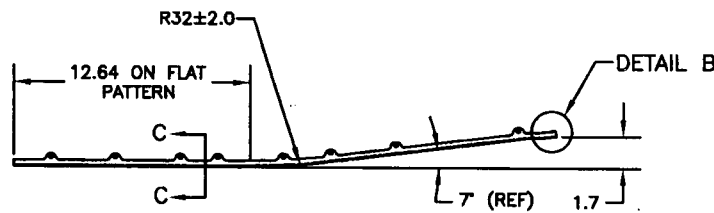
**D3535-39F FLAT PATTERN**



**D3535-39 BEND DETAIL**



**D3535-41F FLAT PATTERN**



**D3535-41 BEND DETAIL**

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT  $\phi$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

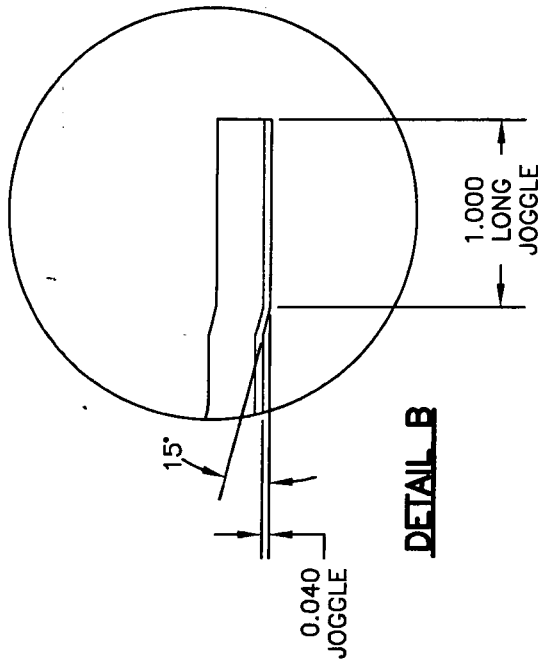
**NOTE:** Date & initial all entries



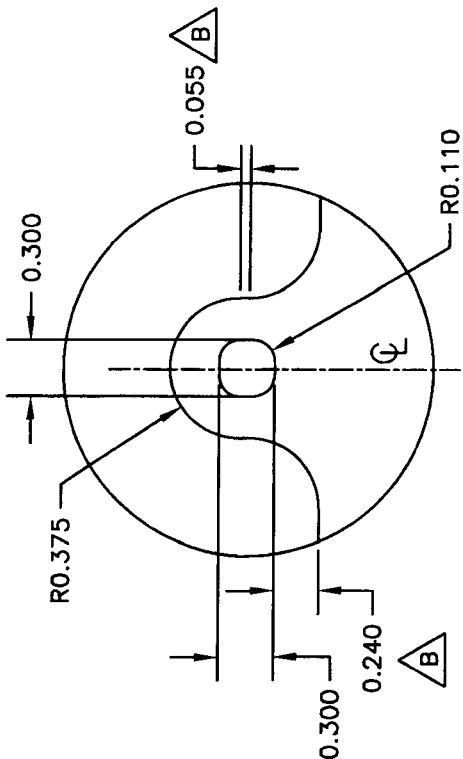
DESIGN <b>CB</b>	DRAWN BY <b>PH</b>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3535	REV. B SHEET 7 OF 7
DATE 07.04.17		TITLE WEARSHOE	SCALE 1:1

RELEASED

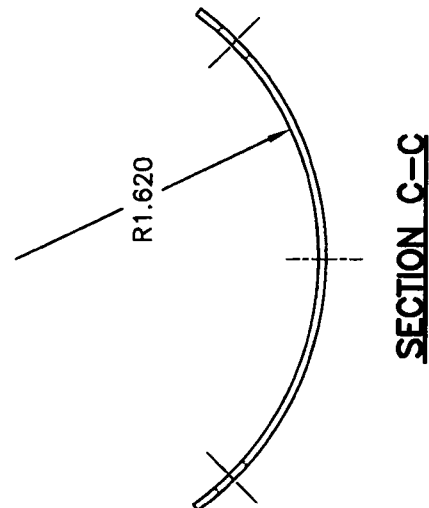
07.04.24 *[Signature]*



**DETAIL B**



**DETAIL A**



**SECTION C-C**

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries